

Work Order ID 153803

Friday, November 25, 2016 7:43:21 AM

153803

Page 1

Item ID: D3447-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Square Spacer

Start Date: 11/28/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: NOV 29 2016

Tooling:

Date:

Run Start

NR1QC: 9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3447	Rev <u>B C 4</u>								
100	Small Fab	0.00				<u>2</u>	<u>FF</u>		JAN 05 2017
100									
Small Fab	Memo	0.00							
Small Fab	Cut to length: 2.000" long as per Dwg D3447 Rev: <u>C</u> DeburIdentify as D3447-3								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00				<u>(2)</u>	<u>17.01.05</u>		
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00				<u>(x2)</u>	<u>2017/01/06</u>		
Hand Finishing									<u>2017/01/06</u> <u>2017</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

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Page 2

Item ID: D3447-3 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 12/5/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M 134092</i> Memo Mask inside wall START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>10:40</i>	0.00 0.00				<i>2</i>	<i>0</i>	<i>17-04-7</i>	<i>33</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>2</i>		<i>17-04-07</i>	<i>38</i> <i>9-89</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>MEZZ-2</i> <i>W/A003</i> Memo	0.00 0.00				<i>2</i>			<i>41</i> <i>9-89</i>

APR 09 2017

DQA: _____ Date: _____



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Item ID: D3447-3 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Square Spacer
Start Date: 11/28/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/5/2016 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

APR 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 153803

153803

Parent Item: D3447-3

D3447-3

Parent Item Name: Square Spacer

Start Date: 11/28/2016

Required Date: 12/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 0		Purchased		No		100	f	18.1091	0.1771	0.372842			

M6061T6TS1 000W 120

FF JAN 05 2017

6061T6 SQ TUBE 1.00 x 1.00 X .120w

Location

Loc Qty

Loc Code

MAT051

18.109107

m126686

10.447157

m136101

7.66195

0.372842

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

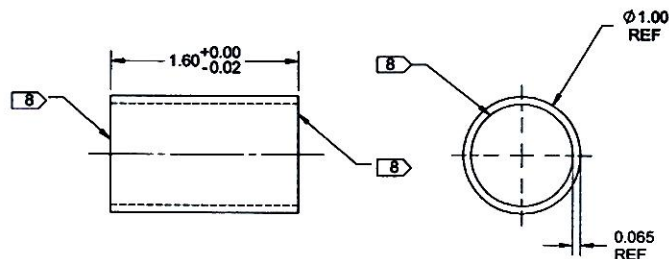
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QC / QA Coordinator Approval																					
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

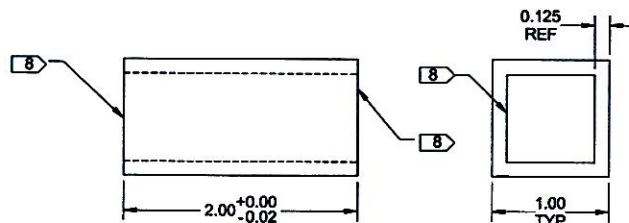
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16-11-29



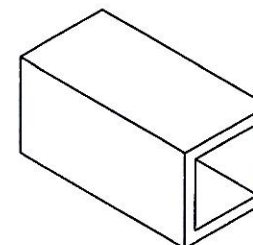
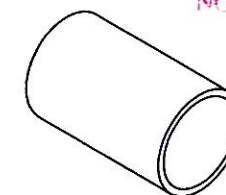
D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
ASTM B221
REF. DART SPEC. M6061T6T1.000W.065



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6T1.000W.125



NOTES:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A OR PER QSI 044 6.1
- 7) WEIGHT: D3447-1 = 0.03 lbs; D3447-3 = 0.09 lbs
- 8) MASKING: INSIDE OF TUBING AND ENDS BEFORE PAINTING.

RELEASED
2016-11-28
ECW 16-678

C	D3447-3: M7075-T6 WAS M6061-T6 (ZN A8-4), REASON IS TO CORRECT PREVIOUS REVISIONS AND TO MATCH PREMIER ORIGINAL DRAWING.	SAD	16.11.22
B	REDRAW TO CURRENT STD: Ø0.280 WAS Ø0.250 (ZN B3-2) AND (ZN C6-3), ADD TOLERANCE (ZN B5/D5-1), UPDATED MATERIAL SPECIFICATION, REASON PAR15-437	SAD	16.08.26
A	NEW ISSUE	MB	05.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3447 TITLE BLADE FOLD KIT PARTS COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	SAD		
CHECKED	MB		
MFG. APPR.	JLM		
APPROVED	WM <i>WM</i>		
DE APPR.	N/A	REV. C	
DATE	16.11.22	SHEET 1 OF 4	
		SCALE NTS	

APPROVED

INSPECTION SHEET

DAS

30
9-89

Date:

Revised by
KJ